

WORK ORDER 2013-46

Date opened: 15 November 2013

Project: Quick Release Cargo Basket Assembly  
Type: Bell 206L Series, 407Batch Quantity: 10 Complete Basket Assembly (69810-01)  
8 Modified with Open Front End (70404)  
8 Modified with Lid Step (70405)Approval: SH00-48  
Drawing List: DCL698-1, DCL704

Fabrication and Assembly Drawing(s)	Description
69810, Rev. 3	Basket Ass'y
69811, Rev. 3	Basket Body Ass'y
69812, Rev. 3	Basket Lid Ass'y
84255, Rev. 1	Handle Installation
84261, Rev. 1	Handle Bar Ass'y
84262, Rev. 1	Handle Bracket Ass'y
70404, Rev. 0	Open Front End Modification
70405, Rev. 2	Lid Step Modification

Complete material tracking information on attached pages.

Work Order pre-completion Inspection:

Project is on Approval Limitation Record:	Y
Document Control List revision level matches (or exceeds) STC:	Y
Drawings revision levels match Document Control List:	Y
Purchase order or Work order source is recorded for each part/ass'y:	Y
Tests and inspections specifically called out on drawings are complete:	Y
Release tags associated with all fabricated parts are attached:	Y
All mounting hardware and supplies are included:	Y

List all non-conformities raised: \_\_\_\_\_

Welder Signature: \_\_\_\_\_ Date: \_\_\_\_\_

Inspector Signature: \_\_\_\_\_ Date: \_\_\_\_\_

Drawing: **69810** Revision 2  
 Assembly: **69810-01** Cargo Basket Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	69810-01	Cargo Basket Assembly			
1	69811-01	Basket Body Assembly	Below		
1	69812-01	Basket Lid Assembly	Below		
1	84255-01	Handle Bar Installation	Below		
1	36280-01	Brace Assembly	9-2081 Brace		
1	MS20001P4	Piano Hinge			
1	69827-01	Placard	0.050" Sheet, 6061-T6 Aluminum	11102	
3	49205-14	Bumper	Argus Industries Bumper	11010	
22	HR3213-5-02	Blind Rivet			
8	HR3523-5-02	Monel Blind Rivet			
4	HR3213-4-02	Blind Rivet			
4	40088-14	Fitting	Ancra		
4	AN960-616	Washer			
1	AN3-15A	Bolt			
1	AN3-17A	Bolt			
4	AN960-10	Washer			
2	AN970-3	Washer			
2	MS21044N3	Nut			

Processes	Per	Mat'l's Used	Inspection	Signature
Riveting	AC43.13-1B	HR3213-5-02, HR3523-5-02 Rivets, HR3213-4-02		
Final Inspection	Drawing 69810			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **69811**      **Revision 2**  
 Assembly: **69811-01**      **Basket Body Ass'y (Quick-Release)**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	69811-01	Basket Body Assembly			
2	69821-01	End Hoop (Rev. 1)	4130 Steel, 1/2" x 0.035 Sqr. Tube		
4	69823-02	Lug	1018 Mild Steel, 5/8" Rod		
3	49210-02	Hoop	4130 Steel, 1/2" x 0.035 Sqr. Tube		
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
4	69825-01	Spine	4130 Steel, 1/2" x 0.035 Sqr. Tube		
2	69826-01	Strut	4130 Steel, 1/2" x 0.035 Sqr. Tube		
1	84262-01	Handle Bracket Assembly	Below		
1	49215-01	Spacer	1018 Steel, 1/2" Rod		
A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'l's Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69811			
Final Inspection	Drawing 69811			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 69812 Revision 1  
Assembly: 69812-01 Basket Lid Ass'y (Quick-Release)

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	69812-01	Basket Lid Assembly			
2	69824-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
2	49212-01	Rim	4130 Steel, 3/4" x 0.035 Sqr. Tube		
3	49213-01	Lid Brace	4130 Steel, 3/4" x 0.035 Sqr. Tube		
1	49216-01	Spacer	1018 Steel, 1/2" Rod		
1	84262-01	Upper Handle Bracket Assembly	Below		
1	36204-10	Placard Bracket	1018 Steel, 0.035" Sheet		
A/R	3/4-16F	Mesh	Expanded carbon steel		

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Powder Coat	Drawing 69812			
Final Inspection	Drawing 69812			

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Tag complete parts / assemblies with Release Tag prior to storage.



Drawing: **84255**      **Revision 0**  
Assembly: **84255-01**      **Handle Installation**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	84255-01	Handle Installation			
1	84261-01	Handle Bar Assembly	Below		
2	84267-01	Bracket	Delrin, 3/4" Sheet		
2	36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire		
2	36275-01	Bushing	SAE 660 Bronze, 5/16" Dia		
2	AN3-12A	Bolt			
4	AN3-11A	Bolt			
12	AN960-10	Washer			
6	MS21044N3	Nut			

Processes	Per	Mat'ls Used	Inspection	Signature
Final Inspection	Drawing 84255			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: 84261 Revision 0  
Assembly: 84261-01 Handle Bar Assembly

Qty Per	Part #	Description	Material	P.O.W.O.	Checked
10 Total	36261-01	Handle Bar Assembly			
1	36277-01	Handle Bar	316 Stainless, 1.0 x 0.035 Rnd. Tube		
2	84265-01	Lever	304 Stainless, 0.105 Sheet		
2	36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	11057	
2	MS20615-4M3	Monel Rivet		7039	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84261			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **84262**      **Revision 0**  
Assembly: **84262-01**      **Handle Bracket Assembly**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
10 Total	84261-01	Handle Bracket Assembly			
4	84272-01	Bushing	4130 Steel, 5/16" x 0.058 Tube	11049	
4	36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	10037	
2	36275-02	Support	304 Stainless, 5/16" Rod	11093	

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER308L		
Final Inspection	Drawing 84262			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

Drawing: **70404**      **Revision 1**  
Assembly: **70404-01**      **Open Front End Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
7 Total	70404-01	Open Front End Modification			
A/R	70404-03	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube		
A/R	70404-04	Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube		
A/R	3/4-16F	Mesh	Expanded Carbon Steel		

Note: Remainder of assembly listed on drawing 69811

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70404			

Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.



Drawing: **70405**      **Revision 0**  
Assembly: **70405-01**    **Lid Step Modification**

Qty Per	Part #	Description	Material	P.O./W.O.	Checked
7 Total	70405-01	Lid Step Modification			
A/R	70405-03	Tube	4130 Steel, 3/4" x 0.035 Sqr. Tube		
A/R	70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"		
18	CR3213-4-2	Cherry Rivet			

Note: Remainder of assembly listed on drawing 69812

Processes	Per	Mat'ls Used	Inspection	Signature
Welding	AMS 2685C	Welding Rod ER70S-2		
Final Inspection	Drawing 70405			

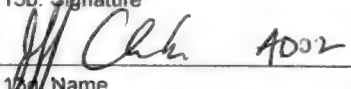
Tag incomplete parts with Work Order # when stored between processes.

Tag complete parts / assemblies with Release Tag prior to storage.

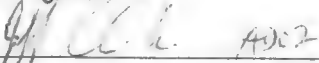


Description: \_\_\_\_\_

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1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-46</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-73</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number
		<b>AMF 73-04</b>				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
<b>Jeff Clarke – AD02</b>		<b>04 Feb 2015</b>				
<b>Installer Responsibilities</b>						
This certificate does not constitute authority to install.						
Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.						
Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						

212 INVESTMENT

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-46</b>
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-69</b>	<b>New</b>
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			<del>         14a. <input type="checkbox"/> CAR 571.10 Maintenance Release  <input type="checkbox"/> Other regulation specified in block 12          Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.       </del>		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		<del>14b. Signature</del>	
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>03 Mar 2014</b>		<del>14c. Approved Organization Number</del>  <del>14d. Name</del>  <del>14e. Date (dd/mmm/yyyy)</del>	
<b>Installer Responsibilities</b> This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.					


Approved



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-46</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-72</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.				<input type="checkbox"/> Other regulation specified in block 12		
<input type="checkbox"/> Non approved design data specified in block 12.				Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature 		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jason Rekve – AD01</b>		13e. Date (dd/mmm/yyyy) <b>27 July 2014</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p style="text-align: center;"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

TRK



1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE <b>FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-46</b>	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work	
	<b>Cargo Basket</b>	<b>69810-01</b>	<b>1</b>	<b>69801-70</b>	<b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12			
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature		13c. Approved Organization Number		14b. Signature		14c. Approved Organization Number
 <b>AD02</b>		<b>AMF 73-04</b>				
13d. Name		13e. Date (dd/mmm/yyyy)		14d. Name		14e. Date (dd/mmm/yyyy)
<b>Jeff Clarke – AD02</b>		<b>29 May 2014</b>				
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

Great Slave

1. Approving Civil Aviation Authority/Country. <b>Transport Canada</b>		2. <b>AUTHORIZED RELEASE CERTIFICATE FORM ONE</b>			3. Form Tracking No.	
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2013-46</b>	
6. Item	7. Description <b>Cargo Basket</b>	8. Part Number <b>69810-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>69801-71</b>	11. Status/Work <b>New</b>	
12. Remarks <b>Modified with Lid Step and Front End Cutout IAW DCL704</b>						
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.				14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke</i> AD02		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature		14c. Approved Organization Number
13d. Name <b>Jeff Clarke – AD02</b>		13e. Date (dd/mmm/yyyy) <b>16 June 2014</b>		14d. Name		14e. Date (dd/mmm/yyyy)
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

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## CARGO BASKET ASSEMBLY - COMMON

2013-46

B 206L/407 std.

### General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407** – Right side only

- 69810, Revision 3 – Standard Low Mounted Basket
- 94510, Revision 0 – Extra-Wide Low Mounted Basket
- 94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
- 76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355** – left or right

- 77610, Revision 1 – Short Basket
- 76410, Revision 3 – Medium Basket (left or right)
- 78410, Revision 2 – Long Basket
- 94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44** – left or right

- 90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B** – right side only

- 80210, Revision 0 – Short Basket
- 80310, Revision 0 – Medium Basket
- 81110, Revision 0 – Long Basket

#### **Bell 429** – right or left

- 95911, Revision 0 – Standard Basket

#### **Bell Medium** – left or right

- 75111, Revision 0 – Standard Basket
- 95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

- 82811, Revision 0 – Standard Basket

#### Options

- 70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2013-46

Date Open: \_\_\_\_\_

### 1. Lid Assembly

APD

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

### 2. Body Assembly

APD

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??



- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

## 3. Hinge Installation

A/06

- a. Prepare hinge.
  - i. Cut hinge to length:
    - 1. 776, 906 – 54"
    - 2. 751, 803 – 70"
    - 3. 698, 764, 945 – 72"
    - 4. 784 – 90"
    - 5. 940, 946, 959 – 95"
  - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
  - i. Locate hinge on basket (standard baskets)
    - 1. centre fore/aft
    - 2. 0.15" – 0.18" up from bottom edge
  - ii. Locate hinge on basket (extra wide baskets)
    - 1. centre fore/aft
    - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - v. Remove hinge and de-burr holes in hinge and basket rim.
  - vi. Cleco hinge to basket with 5/32 clecos.
  - vii. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations



- d. Record PO of hinge and rivets on attached material tracking list.

**4. Install Handle**ADG

- a. Install handle brackets.
- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to ??.
- b. Install handle
- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
  - ii. Grease two 36275-01 bushings with ?. Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to ??.
- c. Check handle
- i. Operate handle to ensure handle does not bind and springs hold handle in.
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

**5. Install lid brace**ADG

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

**6. Final Inspection**

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2013-46Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		69810-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	<u>11010</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		<u>14032</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>13066</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>14032</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>13042</u>
	. . 8		NAS1149F0663P	Washer		<u>13064</u>
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	<u>13089</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>13020</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>14001</u>
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>2014-49</u>
	. . 4		AN3-11A	Bolt		<u>14001</u>
	. . 8		NAS1149F0363P	Washer		<u>13084</u>
	. . 4		MS21044N3	Nut		<u>13093</u>

Work Order: 2013-46Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13085 / 13085
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	20333
	.. 2		AN3-12A	Bolt		13084
	.. 4		NAS1149F0363P	Washer		14048 / 14048
	.. 2		MS21044N3	Nut		13083
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly		2014-28
	. 1		AN3-15A	Bolt		13084
	. 1		AN3-17A	Bolt		13084
	. 2		AN970-3	Washer		13083
	. 3		NAS1149F0363P	Washer		14048
	. 2		MS21044N3	Nut		13083
Step 6				Inspection	None	

Work Order: 2013-46Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

2 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	. . 1		84261-01	Handle Assembly		
	. . 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	. . 2		36275-01	Bushing	Brass, 5/16" Dia	
	. . 2		AN3-12A	Bolt		
	. . 4		NAS1149F0363P	Washer		
	. . 2		MS21044N3	Nut		
Step 5				<i>Lid Brace Installation</i>		
	. 1		36280-01	Brace Assembly		
	. 1		AN3-15A	Bolt		
	. 1		AN3-17A	Bolt		
	. 2		AN970-3	Washer		
	. 3		NAS1149F0363P	Washer		
Step 6	. 2		MS21044N3	Nut		
				<i>Inspection</i>	<i>None</i>	



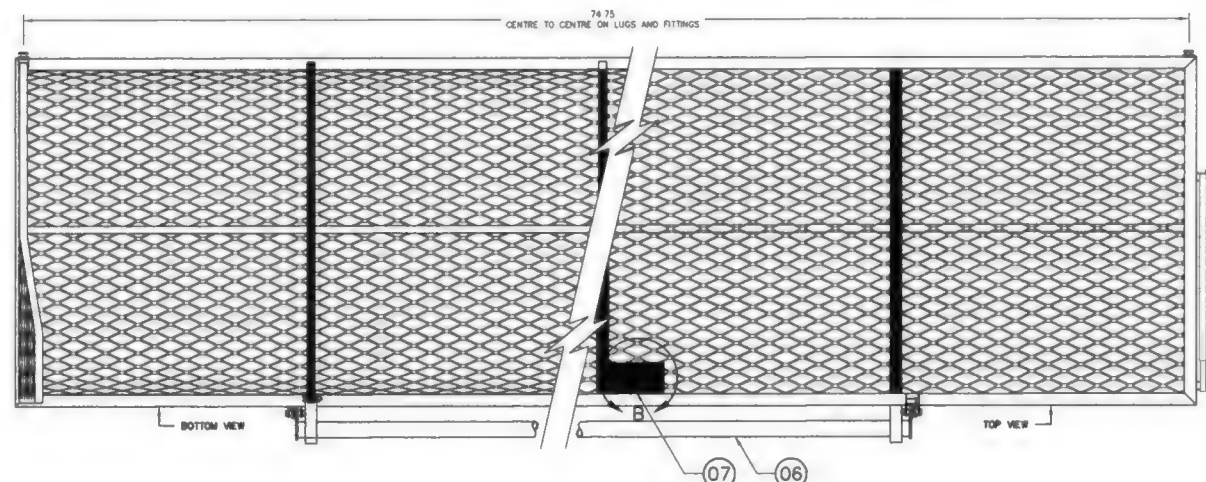
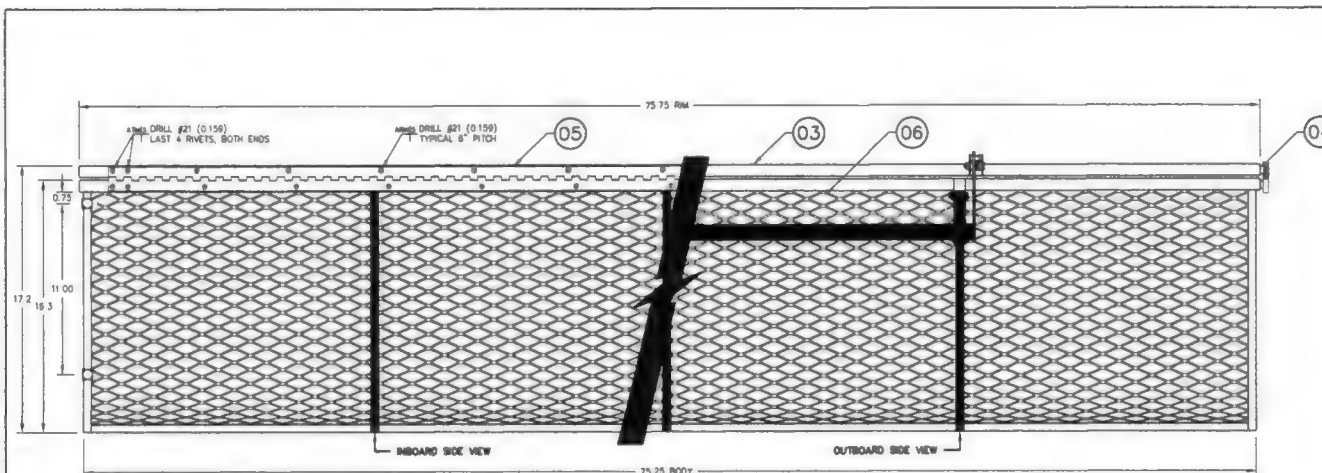
Work Order: 2013-46

Material Tracking Sheet  
Bell 206L / 407  
Standard Basket Assembly

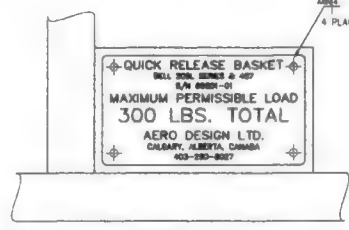
1 of 2

Date Opened: \_\_\_\_\_

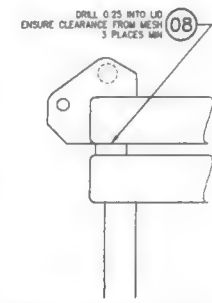
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
			69810-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		69812-01	Basket Lid Assembly		
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		69827-01	Placard	0.063 Sheet, 6061-T6 Aluminum	
	. . 4		CR3213-4-02	Cherry Rivet		
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	
	. . A/R		CR3213-4-02	Cherry Rivet		
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		69811-01	Basket Body Assembly		
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	72"	
	. 8		CR3523-5-02	Cherry Rivet		
	. A/R		CR3213-5-02	Cherry Rivet		
<b>Step 4</b>	. 1	84255	84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		



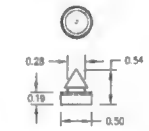
01 CARGO BASKET ASSEMBLY



SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

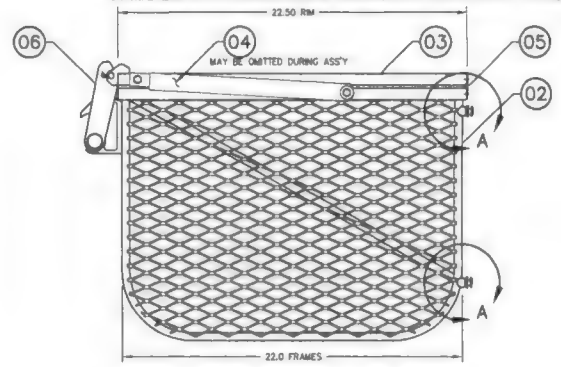


SCALE 1 : 1



SCALE 1 : 1

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED LUGS	BJC	08/11/2009
2	PLACARD CHANGED, AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BJC	23/09/2009
3	HINGE RIVETS CHANGED, HANDLE DETAILS CHANGED, PLACARD CHANGED	BJC	14/10/2011



SCALE 1 : 1

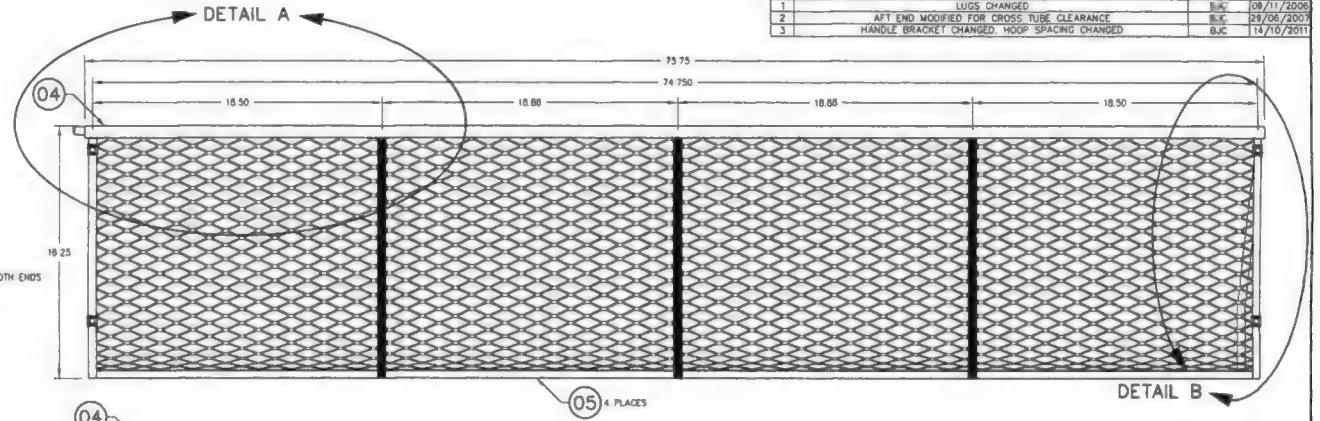
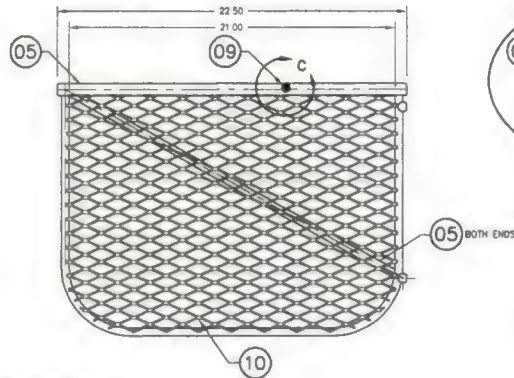
LOOKING AT LOWER ATTACHMENT, UPPER ATTACHMENT SIMILAR  
TYPICAL FRONT AND REAR

NOTE:  
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

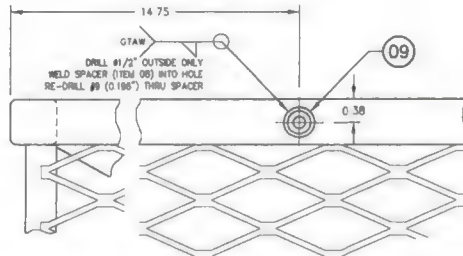
A/R	AN60-618	WASHER				
4	4008-14	FITTING	ANCHRA			
4	CR3213-4-02	CHERRY RIVET				
8	CR3223-5-02	CHERRY RIVET				
A/R	CR3213-5-02	CHERRY RIVET				
3	49205-14	08 BUMPER	ARGUS INDUSTRIES			
1	69827-01	07 PLACARD				
1	84255-01	06 HANDLE BAR INSTALLATION				
1	MS20001P4	05 PIANO HINGE		6 FEET LONG		
1	30280-01	04 BRACE ASSEMBLY				
1	69812-01	03 LID ASSEMBLY				
1	69811-01	02 BASKET BODY ASSEMBLY				
1	69810-01	01 CARGO BASKET ASSEMBLY				
Q1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY				LIST OF MATERIALS		

BASIC CODE REF HAS 323		DASH NO. FOR DIAMETER N=MFD: HEAD NEAR SIDE F=MFD: HEAD FAR SIDE	APPROVALS DRAWN: JEFF CLARKE 11 APR 2008		AERO DESIGN LTD. CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 2908 2013 - 30TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 292-8087 fax: (403) 292-8088 aerodesign@aerodesign.net		
C=COUNTERSINK D=DIMPLE DIGIT=8 OF SHEETS TO BE DIMPLED		DASH NO. FOR LENGTH	CHECKED: E BURGOIN				
BASIC CODES: BJ=MS20470AD B6=MS20426AD ABH=CR3213 ATN=CR3523		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:			BELL 206L, 407 QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY		
		DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1					
		+ ⊕ INSTALL NEW RIVET + ⊕ REMOVE/REPLACE RIVET - ⊕ EXISTING RIVET					
SCALE 1 : 1 SHEET 1 OF 1		DWG NO: 69810		REV: 3			

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	LUGS CHANGED	BLJ	09/11/2006
2	AFT END MODIFIED FOR CROSS TUBE CLEARANCE	BLJ	29/09/2007
3	HANDLE BRACKET CHANGED, HOOP SPACING CHANGED	BLJ	14/10/2011

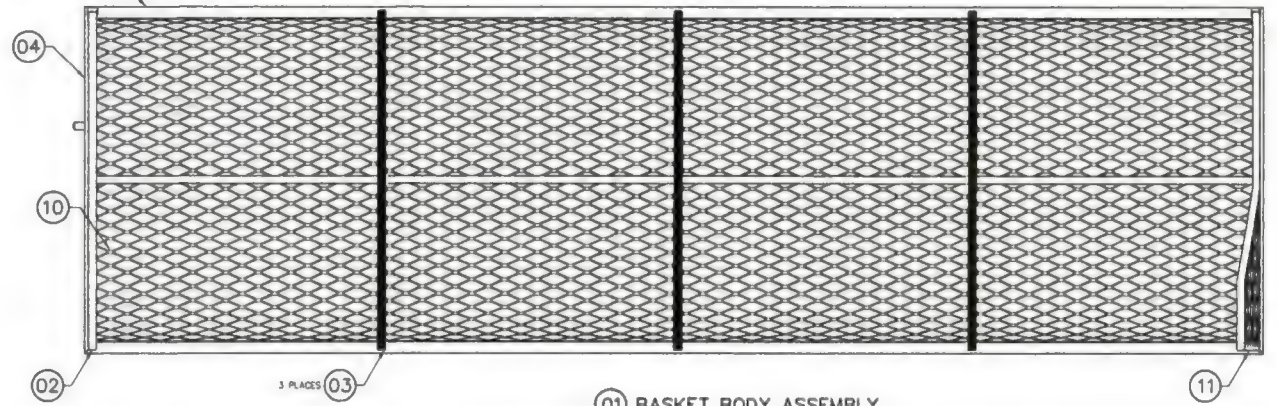


- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C
  3. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD
  5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

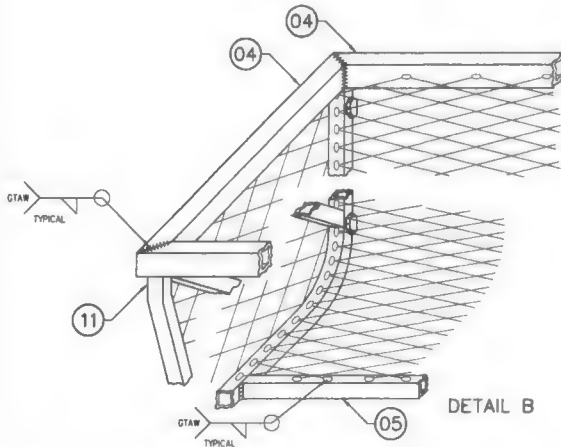


DETAIL C

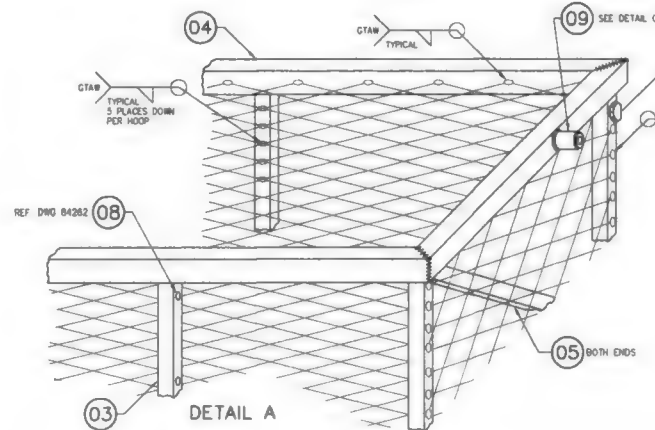
SCALE 1:1  
VIEW LOOKING AT FRONT RIM OF BASKET



01 BASKET BODY ASSEMBLY



DETAIL B



DETAIL A

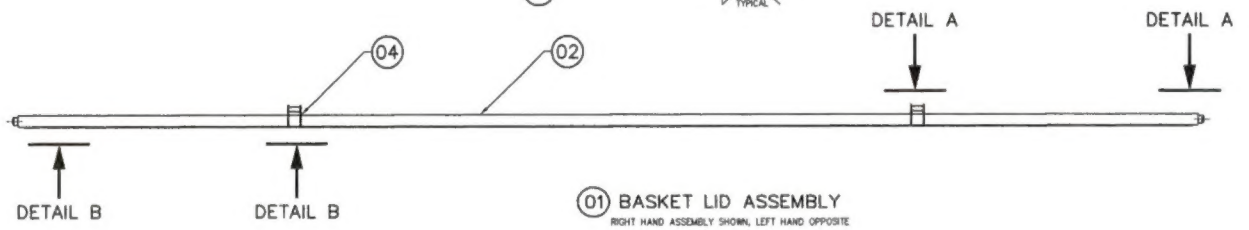
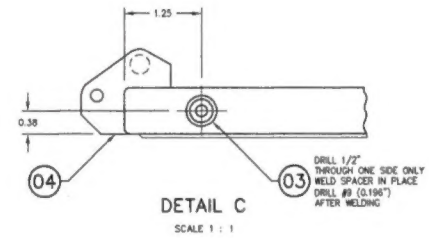
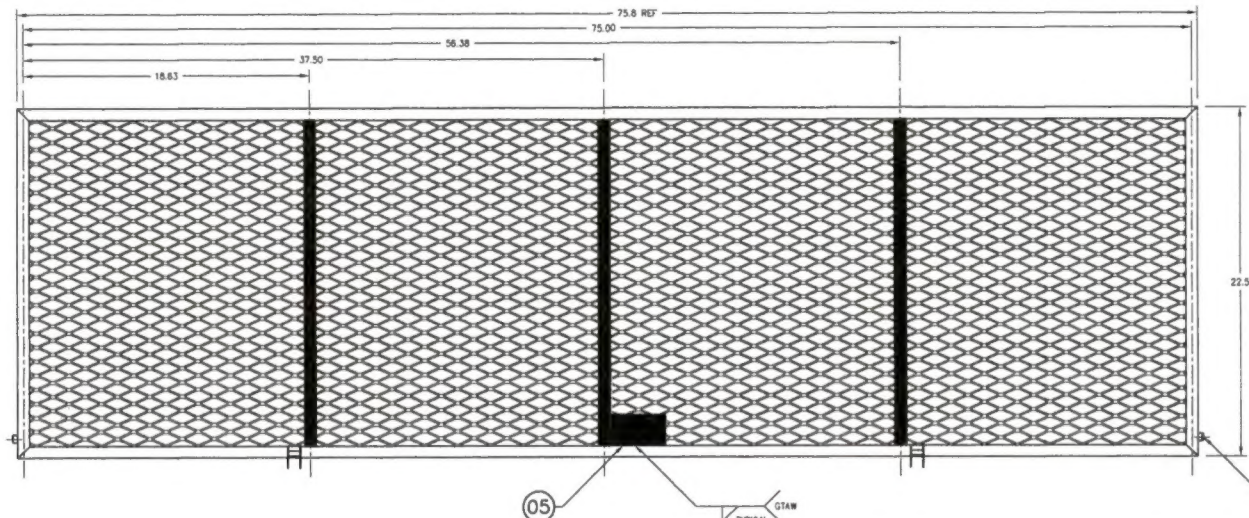
QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	69822-01	11	AFT END HOOP	STEEL	COMMERCIAL	
A/R	3/4-16F	10	MESH			
1	49215-01	09	SPACER			
1	84262-01	08	HANDLE BRACKET ASSEMBLY			
1	07	---	---			
1	06	---	---			
A/R	---	05	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.5 X 0.035 SQR. TUBE
A/R	---	04	TUBE	4130 STEEL, COND. N	MIL-T-6736	0.75 X 0.035 SQR. TUBE
1	49210-02	03	HOOP			
1	69821-01	02	FORWARD END HOOP			
1	69811-01	01	BASKET BODY ASSEMBLY			

APPROVALS	DATE
DRW: JEFF CLARKE	11 APR 2006
CHECKED: E. BURGON	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

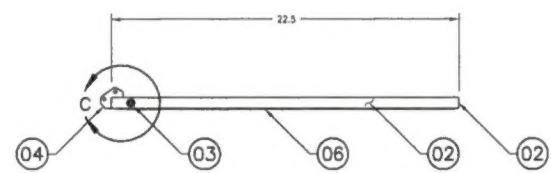
SCALE	1	4	QWS SIZE	QWS NO	REV
SHEET 1 OF 1	A1	69811	3		



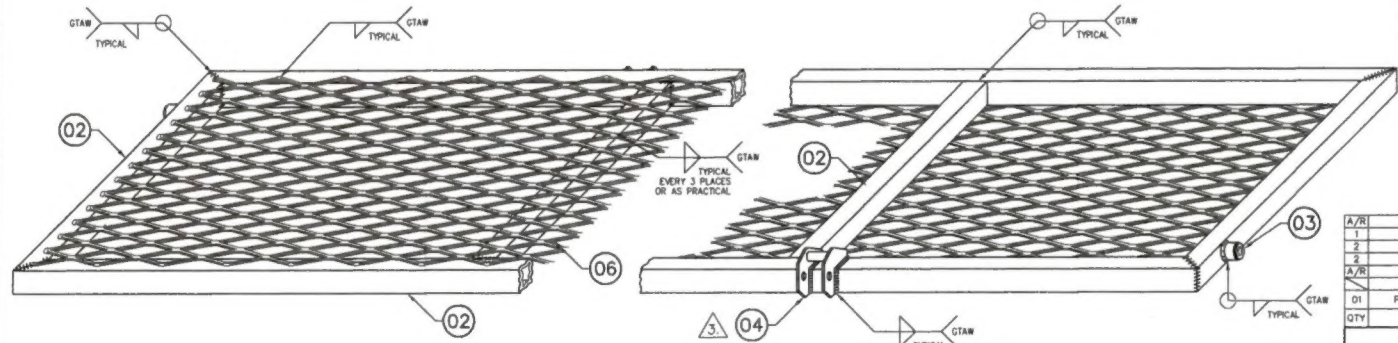
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL RELEASE	RR	20 FEB 08
1	CHANGED LOCATIONS OF SUPPORTS	BUC	28 JAN 10
2	CHANGED HANDLE BRACKETS, ADD LEFT HAND CONFIGURATION	BUC	15 SEPT 11
3	CHANGED LOCATION OF SUPPORTS, REMOVE SIDED CONFIGURATIONS		



01 BASKET LID ASSEMBLY  
RIGHT HAND ASSEMBLY SHOWN, LEFT HAND OPPOSITE



- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
  2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AWS 288SC. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
  3. INSTALL ITEM 6 (HANDLE BRACKET ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84282 TYP 2 PLACES.
  4. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
  5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY.

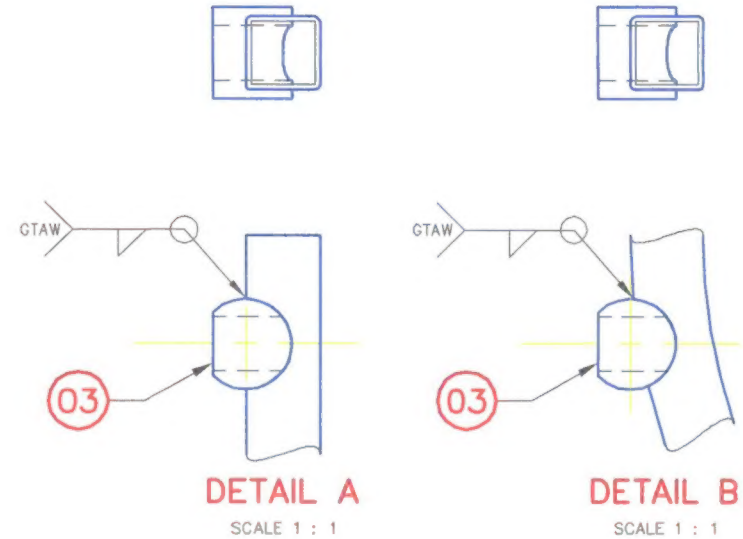
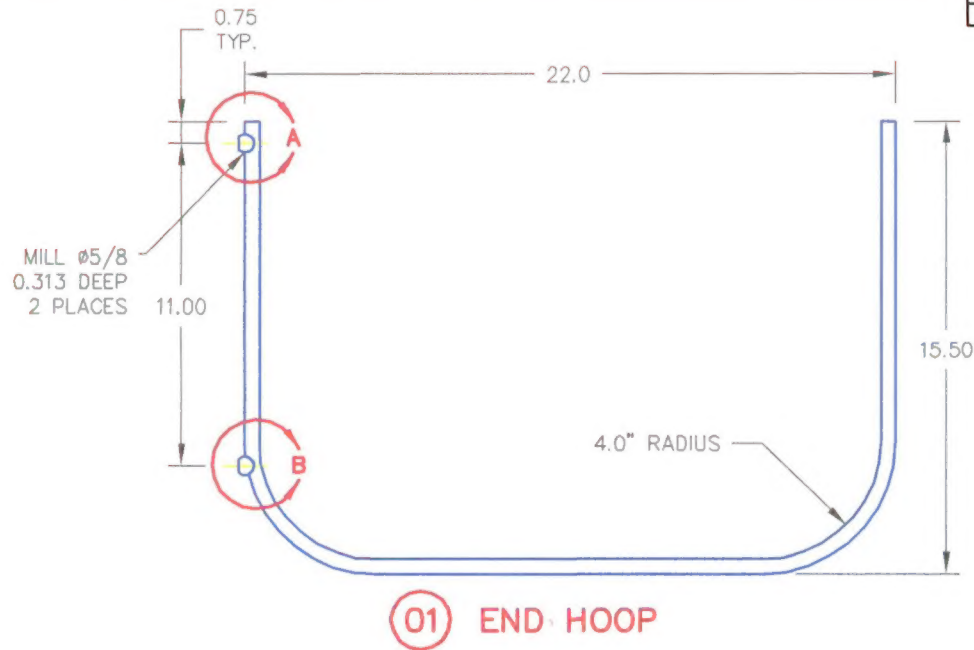


DETAIL B  
LOOKING AT BOTTOM

DETAIL A  
LOOKING AT TOP

A/R	3/4-16F	06	MESH	MILD STEEL	COMMERCIAL	
1	36204-10	05	PLACARD BRACKET			
2	84282	04	UPPER HANDLE BRACKET ASSY			
3	49216-01	03	SPACER			
A/R	--	02	TUBE	4130 STEEL, COND. N	MIL-T-8736	0.75 X 0.035 SQ. TUBE
01	69812-01	01	BASKET LID ASSEMBLY			
D1	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
APPROVALS						
DRAWN: JEFF CLARKE			11 APR 2006			
CHECKED: E. BURGOIN						
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:						
DECIMALS			ANGLES			
X.XXX ±0.010			±1/2"			
X.XX ±0.03						
X.X ±0.1						
AERO DESIGN LTD.						
CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 590M 2013 - 59TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 Tel: (403) 550-8007 Fax: (403) 550-8003 aerodesign@aerodesign.net						
QUICK RELEASE CARGO BASKET BASKET LID ASSEMBLY						
SCALE 1 : 4			DWG. SIZE		DWG. NO. REV.	
SHEET 1 OF 1			A1		69812 3	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVED LUG (ITEM 2), BOTH LUGS NOW ITEM 3	BJC	09/11/2006



#### NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. DRILL 3/32 VENT HOLE IN BOTTOM OF HOOP FOR VENTING OF WELD GASES
3. WELDING OF STAINLESS STEEL LUGS TO BE COMPLETED BY GTAW METHOD TO AMS2685C. WELDING ROD SHALL CONFORM TO AMS 5680 (347 STAINLESS STEEL) OR EQUIVALENT.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
2	69823-02	03	LUG	304 STAINLESS STEEL	ASTM A476	5/8 DIA ROD
	69821-01	01	END HOOP	4130 STEEL COND. N	MIL-T-6736	1/2 x 0.035 SQR. TUBE

#### LIST OF MATERIALS

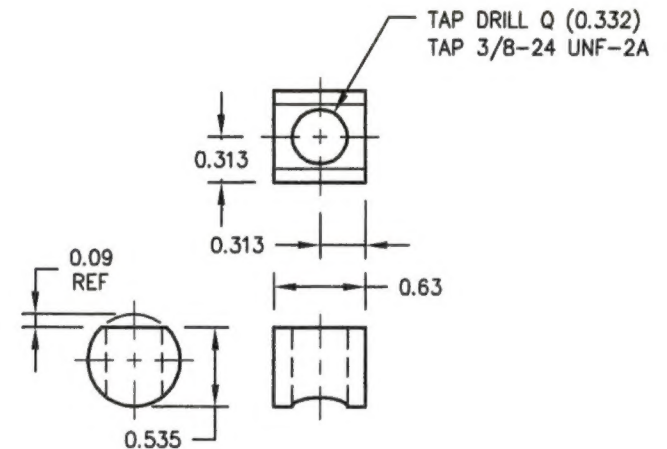
<b>APPROVALS</b> DRAWN: JEFF CLARKE CHECKED: E. BURGON		<b>DATE</b> 10 APR 2006		<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027 fax: (403) 250-8333 aerodesign@telusplanet.net	
<b>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES.</b> <b>TOLERANCES ON:</b> DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1		SCALE 1 : 5 SHEET 1 OF 1		DWG. SIZE <b>LGL 69821</b>	
				REV. 1	

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NOTICE



REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	REMOVE LUG (ITEM 1)	BJC	27/02/2007



02 LUG

69823-02	02	LUG	1018 MILD STEEL	AISI 1010/1020	5/8 DIA ROD
	01				
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS				

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	DRAWN: JEFF CLARKE	10 APR 2006	CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M			
	CHECKED: E. BURGOIN		2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7			
			tel: (403) 250-8087 fax: (403) 250-8333 aerodesign@telusplanet.net			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		BELL 206L, 407			
DECIMALS ANGLES		QUICK RELEASE CARGO BASKET				
X.XXX ±0.010 ±1/2°		BASKET COMPONENTS - LUGS				
X.XX ±0.03		SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
X.X ±0.1		SHEET 1 OF 1	LGL	69823	1	

**NOTICE**

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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
1	CHANGED TO ENGRAVED ALUMINUM	BJC	19 JUNE 2007
2	INCREASED LOAD	BJC	26 OCT 2011

**NOTES**

1. ENGRAVE 0.007 DEEP AS FOLLOWS:  
"QUICK RELEASE BASKET" - 0.125 HIGH  
"BELL 206L SERIES & 407" - 0.080 HIGH  
"S/N 69801-XX" - 0.080 HIGH  
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH  
"300 LBS. TOTAL" - 0.200 HIGH  
"AERO DESIGN LTD." - 0.125 HIGH  
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH  
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES



① PLACARD

1	69827-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
		APPROVALS	DATE	<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290M 2013 - 39TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6R7 tel: (403) 250-8027      fax: (403) 250-8333      aerodesign@telusplanet.net		
		DRAWN: JEFF CLARKE	24 APR 2006			
		CHECKED: E. BURGOIN				
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS                      ANGLES X.XXX    ±0.010                      ±1/2" X.XX     ±0.03 X.X      ±0.1		BELL 206L SERIES AND 407 QUICK RELEASE CARGO BASKET PLACARD		
		SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.	
		SHEET 1 OF 1	A4	69827	2	